

Work Order ID 57539

split - 2 LF 10/04/19



April 8, 2010 8:54:28 AM

Page 1

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Item Name: Float Web (206L/407)

Stop



Start Date: 4/08/10 Start Qty: 10.00



Required Date: 4/16/10 Req'd Qty: 10.00 9.0

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: C2

Date: 10/4/08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3282

Rev C

100



Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.  
per QSI0018

12- inspect for surface damage as

10

10/4/15

110



HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS CNC vertical machine #1

Memo

0.00

1-Machine as per Folio FA579 & Dwg D3282 2-Deburr

split 10/04/17

9

0

120



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

0.00

split 10/04/17

9

0





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Page 2

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Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

2L 10/04/19



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

9 - - AWM 10-4-20

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

10-4-20 9

(P)



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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web. 1A/RN/ALPS-3 M104929

DP/H

10/14/22

170

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

5/10/27

(P)

180

0.00



Packaging

Packaging

Identify as per dwg & Stock Location: L.G.

Memo

0.00

H 10/11/22





# Work Order ID 57539

April 8, 2010 8:54:29 AM



Page 4

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

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Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/28 JF  
ME  
10-4-27





# Picklist Print

April 8, 2010 8:54:27 AM

Page 1

Work Order ID: 57539

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)


Comments: IPP Rev:B (05.09.23) Procedure change KJ/JLM

Start Date: 4/08/10

Required Date: 4/16/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2792-130  EXTRUSION		Manufactured	No			160	Each	28.0000	10.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT06

28

42366

28

160

Each

17.0000

20.0000

10

4/10/4/15

D3283-1



Doubler

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST048

17

52904

17

100

Each

2,530.000

570.0000

17

4/10/5/22

MS20470AD4-7



Rivet, Universal Head

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST320

2530

112492

2530

514

4/10/4/22

#1





DART AEROSPACE LTD		Work Order: 57539
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.625	✓			
1.500	+/-0.010	1.500	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	6.00	✓			
1.250	+/-0.010	1.250	✓			
30.000	+/-0.010	30.00	✓			
1.500	+/-0.010	1.50	✓			
72.01	+/-0.030	72.01	✓			
61.75	+/-0.030	61.62	✓			
57.50	+/-0.030	57.50	✓			
49.19	+/-0.030	49.19	✓			
43.94	+/-0.030	43.44	✓			
39.69	+/-0.030	39.69	✓			
26.68	+/-0.030	26.68	✓			
0.55	+/-0.030	.550	✓			
1.970	+/-0.010	1.970	✓			
2.38	+/-0.030	2.38	✓			
0.05	+/-0.030	.05	✓			

Measured by: SP
Date: 10/04/17

Audited by: SL
Date: 10/04/17

Prototype Approval:	N/A
Date:	N/A

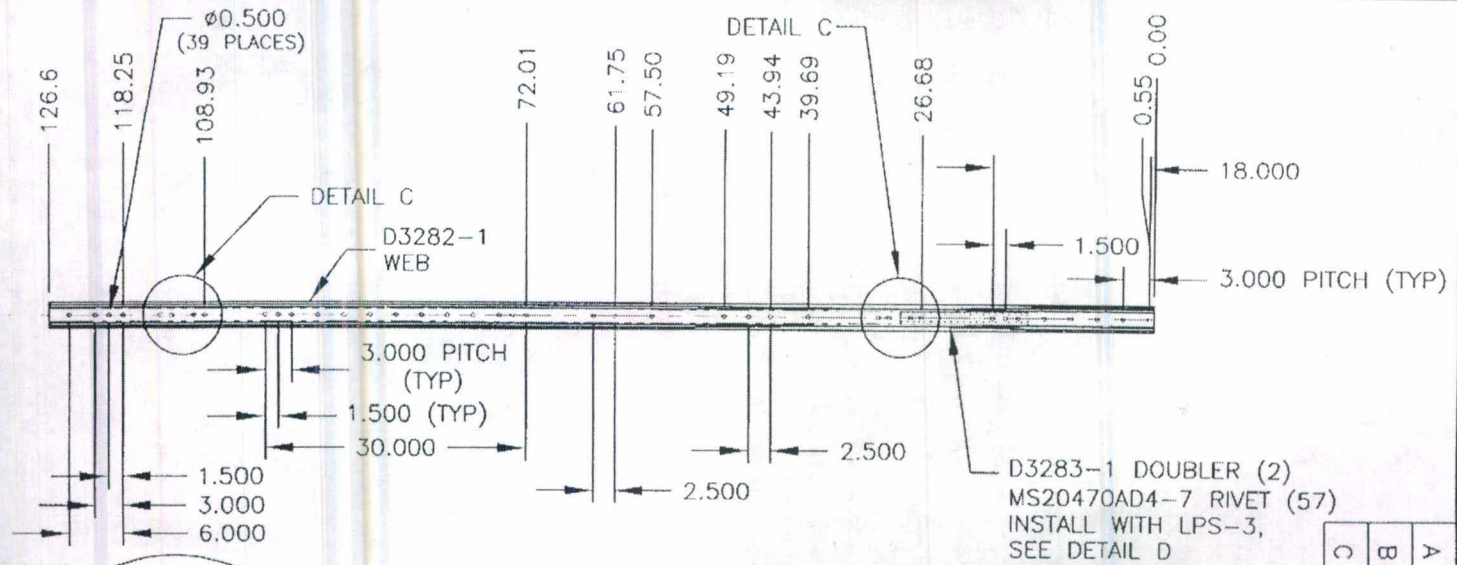
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	



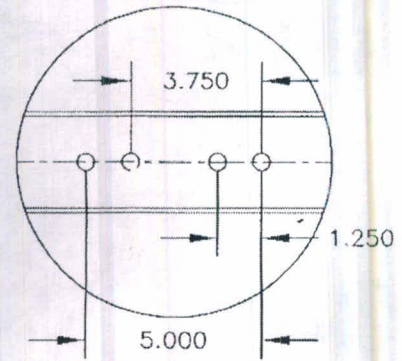




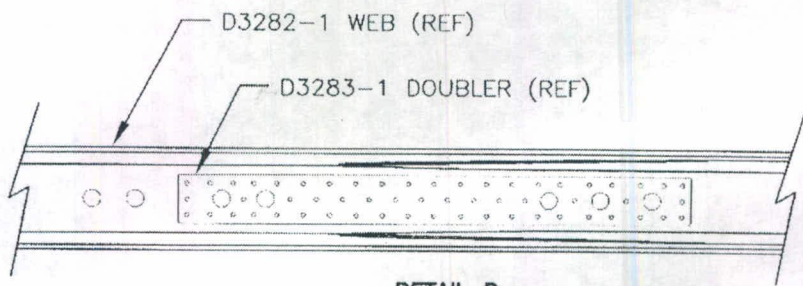
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CP	CP	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
#	#	D3282	SHEET 1 OF 2	
DATE		TITLE	SCALE	
05.08.09		FLOAT WEB, 206L/407	1:20	
A	04.05.05	NEW ISSUE		
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS		
C	05.08.09	REMOVE D3390-1, NOW MACHINED		



D3283-1 DOUBLER (2)  
MS20470AD4-7 RIVET (57)  
INSTALL WITH LPS-3,  
SEE DETAIL D



**DETAIL C**  
SCALE 1:5  
RIVET HOLES NOT SHOWN  
FOR CLARITY



**DETAIL D**  
SCALE 1:5

W/O 57539

RELEASED  
05/12/12

**D3282-041 FLOAT WEB**



- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

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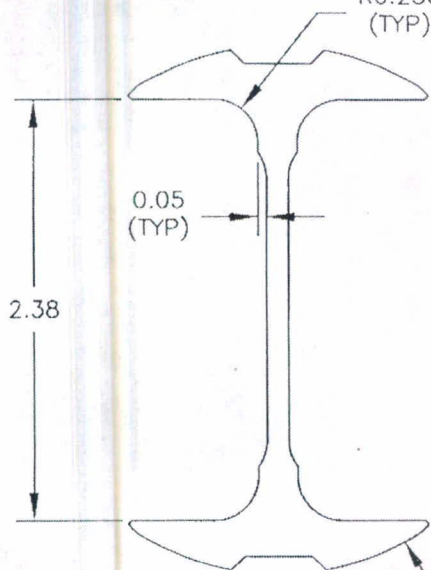


DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
CHECKED		APPROVED		DRAWING NO.	REV. C
				D3282	SHEET 2 OF 2
DATE				TITLE	SCALE
05.08.09				FLOAT WEB, 206L/407	1:20

SECTION A-A

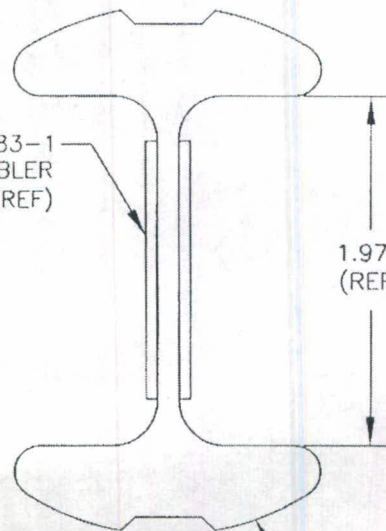
R0.250  
(TYP)



2.38

0.05  
(TYP)

SECTION B-B



1.970  
(REF)

D3283-1  
DOUBLER  
(REF)

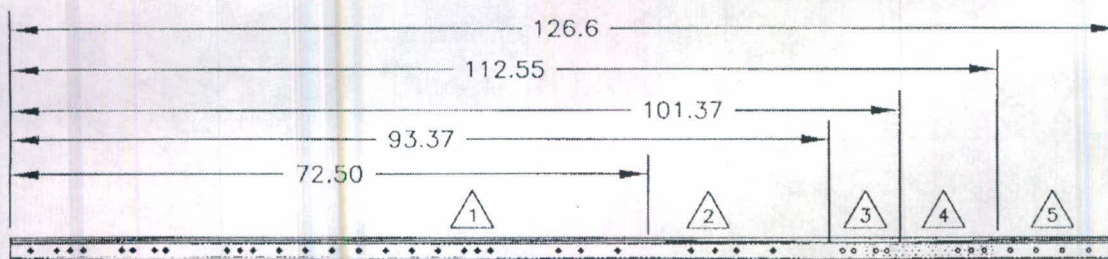
D2792-130  
EXTRUSION  
(REF)

- D2792-130  
EXTRUSION  
(REF)

D3282-1 MACHINING NOTES

- |   |   |           |
|---|---|-----------|
| 1 | UNIFORM SECTION A-A   | (REF)     |
| 2 | UNIFORM TAPER FROM SECTION A-A TO SECTION B-B   |           |
| 3 | UNIFORM SECTION B-B   |           |
| 4 | UNIFORM TAPER FROM SECTION B-B TO SECTION A-A<br>DRILL #30 ( $\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,<br>SEE DETAIL D FOR REFERENCE |           |
| 5 | UNIFORM SECTION A-A   |           |
| 6 | R1.00 BETWEEN SECTIONS  | W/O 57534 |

w/o 57534



25-09-2

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